

Work Order ID 77674

December-16-11 11:09:16 AM

77674

Page 1

Item ID: D3219-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 16/12/2011 Start Qty: 60.00

60

Cust Item ID:

Required Date: 23/12/2011 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/12/14

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D3219								
606.105	Dwg Rev: A								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	Memo	0.00							
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120	Memo	0.00							
QC									
Quality Control									

S.112/23

counts

x72

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77674

December-16-11 11:09:16 AM

77674

Page 2

Item ID: D3219-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 16/12/2011 Start Qty: 60.00

60

Cust Item ID:

Required Date: 23/12/2011 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

0.00

11/12/23

72

0

Small Fab

Memo

0.00

Small Fab

1-Deburr if necessary.

140

140

QC5- Inspect part completeness to step on W/O

0.00

11/12/23

QC

Quality Control

150

150

Identify as per dwg & Stock Location: W4

0.00

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

11/12/23

72

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77674

December-16-11 11:09:16 AM

77674

Page 3

Item ID: D3219-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 16/12/2011 **Start Qty:** 60.00

60

Cust Item ID:

Required Date: 23/12/2011 **Req'd Qty:** 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

160

160

QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

11/12/28 JY

Memo

0.00

11/12/23
JY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-16-11 11:09:21 AM

Page 1

Work Order ID: 77674

77674

Parent Item: D3219-1

D3219-1

Parent Item Name: Plate

Start Date: 16/12/2011

Required Date: 23/12/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A04.04.19 New issue KJ/JLM
 ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	71.8400	0.0964	6.088421	7,	16/12/2011	**

M6061T6S 125

6061-T6 .125 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	71.84	
113608	57.35	
118217	14.49	118217

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77674
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	<u>11-12-22</u>	Date:	<u>11/12/23</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	
C	08.04.15	0.125 dimension removed	KJ/DD	✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COPY
ONE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3219 REV. A
DATE		SHEET 1 OF 1
03.10.10		SCALE 1:1
A	03.10.10	NEW ISSUE

RELEASED
04.04.05

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

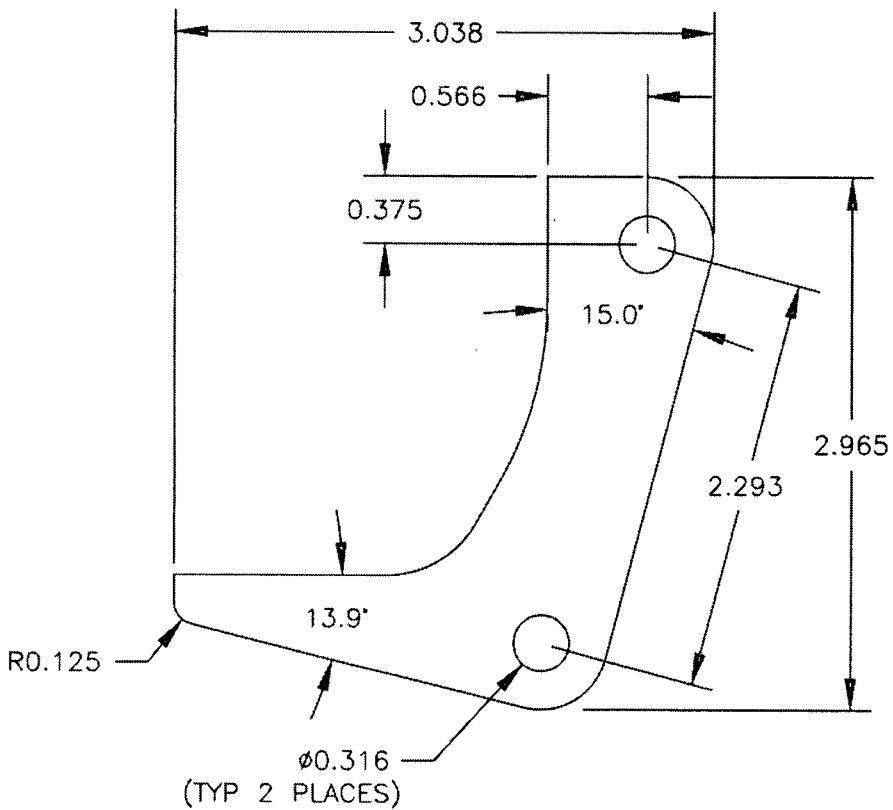
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 73674

M.L.J
11/12/14



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDprt"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries